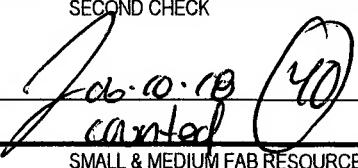
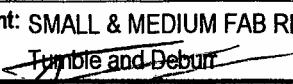
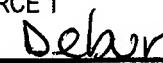
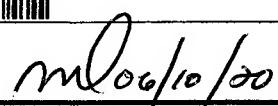


Date: Monday, 16/10/2006 7:48:36 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HINGE BRACKET
Job Number	: 28948		
Estimate Number	: 10224		
P.O. Number	: N/A	Part Number	: D2143
This Issue	: 16/10/2006 S.O. No. : N/A	Drawing Number	: D2143 REV. C1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: C1
Previous Run	: 28948 Type : SMALL /MED FAB	Material	: N/A
Written By	: <u>L</u>	Due Date	: 19/10/2006 Qty: 40 Um: Each
Checked & Approved By			
Comment	: Est C 00.05.18 Added inspection level 8 Est Rev:D Now on WaterJet 06-10-15 JLM EC		

Additional Product

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040 	5052-H32 .040 Sheet 
Comment: Qty.: 0.0693 sf(s)/Unit Total : 2.7720 sf(s) Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Batch: M101875 M 06 10 18		
2.0	WATER JET 	FLOW WATER JET 
Comment: FLOW WATER JET 1-Cut as per Dwg D2143 Dwg Rev: C1  06 10 18  Prog Rev: C1 		
2-Deburr if necessary		
3.0	QC2 	INSPECT PARTS AS THEY COME OFF MACHINE 
Comment: INSPECT PARTS AS THEY COME OFF MACHINE  		
4.0	QC8 	SECOND CHECK 
Comment: SECOND CHECK 		
5.0	SMALL FAB 1 	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1    		

Date: Monday, 16/10/2006 7:48:36 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HINGE BRACKET

Job Number: 28948

Part Number: D2143

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D2143

50 06/10/24 (40)

7.0 QC5 INSPECT WORK TO CURRENT STEP



Jan 10 24 (40)

Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MM

06/10/25

(40)

9.0 POWDER COATING POWDER COATING



1101575

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

YL 06/10/26 X 40

10.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 06/10/27 (40)

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 25

PV 06/10/27 (40)

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DP 06/10/27

Job Completion



06/10/27

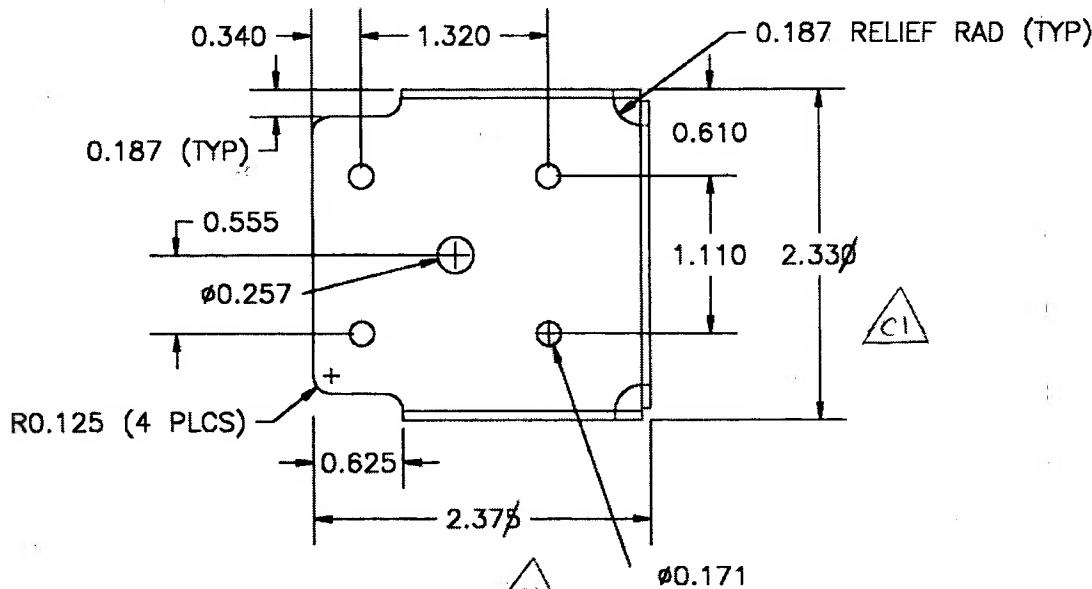
DART AEROSPACE LTD	Work Order:	28948
Description: Hinge Bracket	Part Number:	D2143
Inspection Dwg: D2143	Rev: C1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>M. M</i>	Audited by:	<i>J</i>	Prototype Approval:	N/A
Date:	<i>06-10-18</i>	Date:	<i>06-10-18</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	SJL



SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28948

MATERIAL: 5052-H34, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

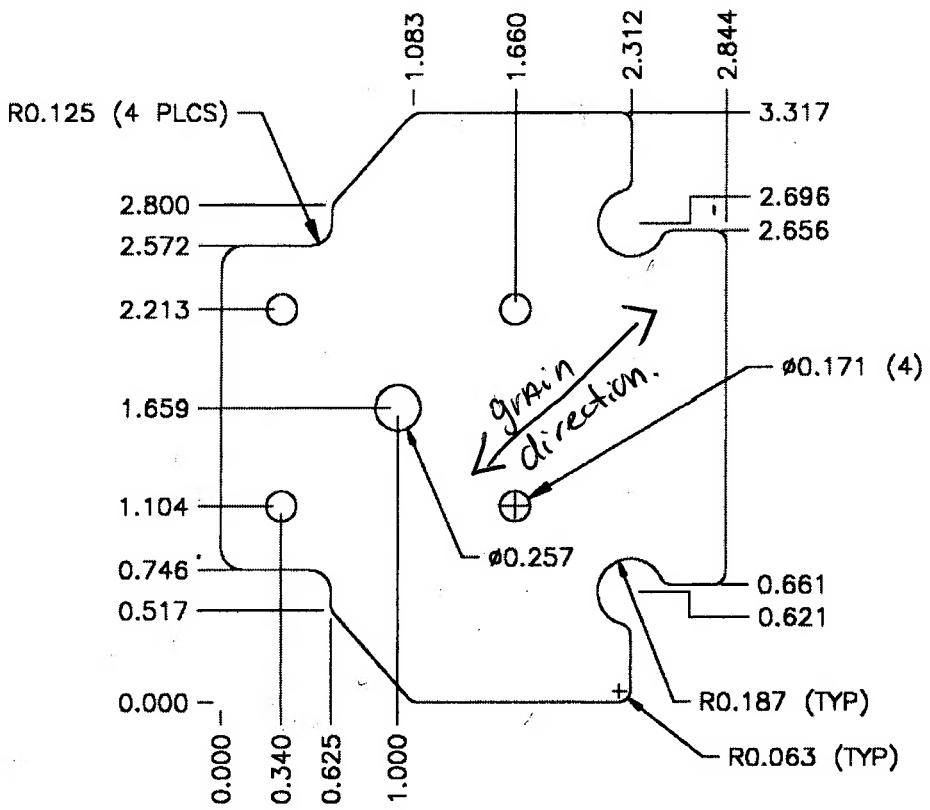
RELEASED
960626 Rev. 2



DESIGN		DRAWN BY	DART AEROSPACE LTD		
J BRADLEY	K HAND	APPROVED	VICTORIA INTERNATIONAL AIRPORT, CANADA	REV. C	SHEET 1 OF 2
C 3	POL	D2143			
DATE			TITLE		
92.07.10			HINGE BRACKET		
B	96.06.06		ADD FLAT PATTERN		
C	96.06.13		MATERIAL WAS 2024-T3 .063 THICK		
C1	A K 04.06.15		UPDATE DIMENSIONS		

DARTQA COPY
DRAFTS

DESIGN J. BRADLEY	DRAWN BY K. HAND	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>Bon</i>	APPROVED <i>Bon</i>	DRAWING NO. D2143	REV. C SHEET 2 OF 2
DATE 95:10:18		TITLE HINGE BRACKET FLAT PATTERN	SCALE 1:1

RELEASED
96-56-20-W

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WORK ORDER
NO. 28948

diagonal grain direction.

MATERIAL: 5052-H34, 0.040 THICK GRAIN ALONG 3.317